

Spld-

Work Order ID 58514-1

10, 2010 7:18:39 AM

Item ID: D2056
Revision ID:
Item Name: Bell Crank
Start Date: 5/10/10
Required Date: 5/11/10
Reference:
Start Qty: 10.00
Req'd Qty: 10.00



Accept



Setup Start
Stop



Cust Item ID:
Customer:

Approvals: Process Plan: QC: *W*
Date:
Date:

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D2056

Rev B2



Bandsaw
Jeaspa Bandsaw

BAND SAW

Memo
Cut blanks 2.80" long

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Set Up/
Run Hours

Draw Number Draw Rev. Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

0.00

0.00

MJP
10/05/10

10

0.00

0.00

MJP
10/05/10

(2)

0.00

0.00

MJP
10/05/10

(2)

QC2- Inspect parts off machine FAI/FAIB

Memo

110
HAAS 1
HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo
Machine as per folio D2056
Tumble
Deburr

120
QC
Quality Control



100-100000-1



Work Order ID 58514

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Page 2

Item ID: D2056

Revision ID:

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Start Date: 5/10/10

Required Date: 5/11/10

Reference:

Start Qty: 10.00

Req'd Qty: 10.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

Jim 10.05.10

(2) ✓

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Hand Finishing

Memo

0.00

JS 10/05/10

2 ✓

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

0.00

=> JS 10/05/10

2 ✓

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*1:30pm
320°F
2:00pm*

Doc ID: 3351

Date:

Time:

Location:

Notes:

Remarks:

Signature:

Initials:

Stamp:

Barcode:

Serial:

Batch:

Lot:

Unit:

Weight:

Volume:

Temperature:

Humidity:

Pressure:

Altitude:

Speed:

Direction:

Acceleration:

Rotation:

Magnetic Field:

Gravitational Field:

Electromagnetic Interference:

Radio Frequency:

Acoustic Noise:

Vibration:

Shock:

Impact:

Friction:

Wear:

Corrosion:

Failure:

End of Document

Work Order ID 58514

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Item ID: D2056

Revision ID:

Item Name: Bell Crank

Start Date: 5/10/10 Start Qty: 10.00

Required Date: 5/11/10 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

②

BR 10-5-10

170

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

MF 10-5-10

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/12

MF 10-5-10

Order ID: 28214



Product Name: Laptop

Product ID: 12345

Product ID: 12345

Product ID: 12345

Product ID: 12345



Picklist Print

May 10, 2010 3:10:47 PM

Page 1

Work Order ID: 58514

Parent Item: D2056

Parent Item Name: Bell Crank

Comments: IPP E 02.04.04 Added Rev.B2 NG

Start Date: 10/05/2010

Required Date: 11/05/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	20.2942	0.2375			

6061-T6 Bar 1.25 x 1.25

Location

MAT03

106259

110001

Loc Qty

20.29421053

10.0192105

10.275

Loc Code

MJD
10/05/10

2205

DART AEROSPACE LTD		Work Order:
Description: Bell Crank		Part Number: D2056
Inspection Dwg: D2056	Rev: B2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

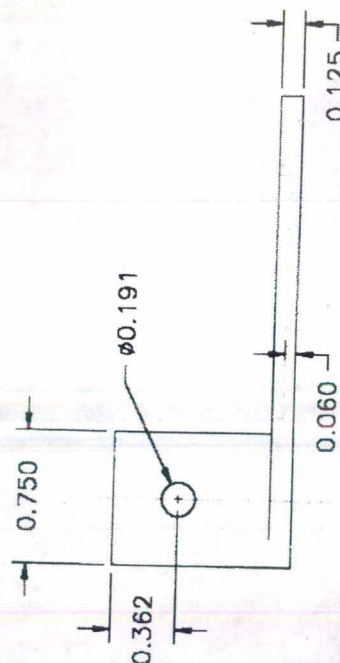
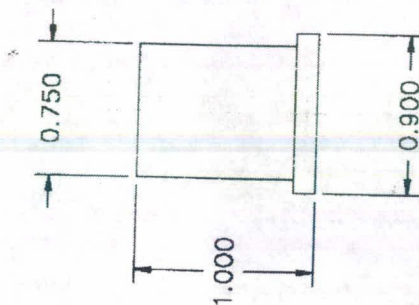
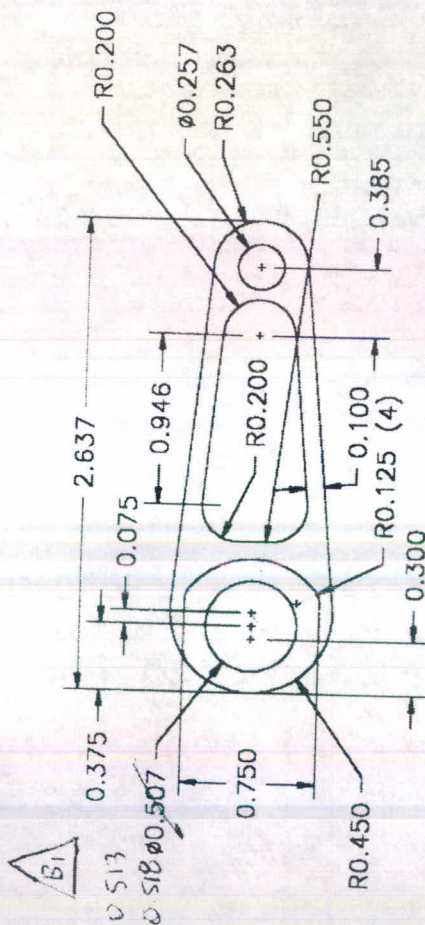
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	.753	✓			
0.900	+/-0.010	.900	✓			
1.000	+/-0.010	.998	✓			
0.125	+/-0.010	.123	✓			
0.060	+/-0.010	.062	✓			
Ø0.191	+0.005/-0.001	Ø .191	✓			
0.362	+/-0.010	.362	✓			
0.750	+/-0.010	.754	✓			
0.385	+/-0.010	.385	✓			
Ø0.257	+0.006/-0.001	Ø .260	✓			
0.100	+/-0.010	.100	✓			
0.300	+/-0.010	.300	✓			
0.946	+/-0.010	.946	✓			
0.075	+/-0.010	.075	✓			
2.637	+/-0.010	2.637	✓			
0.375	+/-0.010	.374	✓			
Ø0.513-0.518	0.513 - 0.518	Ø .516	✓			
R0.450	+/-0.010	R .450	✓			
R0.125	+/-0.010	R .125	✓			
R0.200	+/-0.010	R .200	✓			
R0.550	+/-0.010	R .550	✓			
R0.263	+/-0.010	R .263	✓			

Measured by: <i>mm</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 10/05/10	Date: 10-05-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	
B	10.02.02	Dimensions revised	KJ	<i>[Signature]</i>



DESIGN	B WILLIAMS	DRAWN BY	K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	<i>BW</i>	APPROVED	<i>KE</i>	DRAWING NO.	REV. B
DATE	92:03:13			D2056	SHEET 1 OF 1
				TITLE	SCALE
				BELL CRANK	1:1
B	95:11:02	RE-DESIGN			
B1	<i>PT</i> 01.02.04	MODIFY HOLE SIZE, ADD PIC OPTION			
B2	<i>PT</i> 01.12.20	ADD NOTE ON TOLERANCES			



ACID ETCH & ANODIZE FOR
DART USE US 4.1
PUMP USE FURTHER SHIMMED
(4.3.7) FOR DART
USE US 4.3

MATERIAL: 6061-T6 (QQ-A-225/B)
FINISH: ANODIZE (BLACK) OR
TOLERANCES ARE FOR DART USE OR UNLESS OTHERWISE NOTED

